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(54) **PROCESS FOR PRODUCTION OF CAMPTOTHECIN DERIVATIVE**

(57) Disclosed is a process for production of 7-ethyl-10-[4-(1-piperidino)-1-piperidino]-carbonyloxycamptothecin from a camptothecin composition containing 18,19-dehydrocamptothecin without producing any vinyl form of the compound. The process is **characterized by**

catalytically reducing at least one compound selected from a compound (1) and others in the process of producing a compound (5) from a composition containing the compound (1).

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Description

[Technical field]

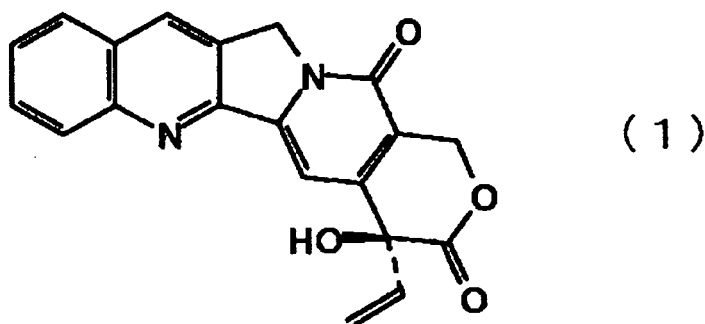
5 **[0001]** The present invention relates to a process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin and its derivatives.

[Background art]

10 **[0002]** Camptothecin (hereinafter, referred to as CPT) is a pentacyclic alkaloid isolated from natural materials such as *Camptotheca acuminata*, Nyssaceae, which is native to China. Various effective semi-synthetic derivatives having anti-tumor activity prepared using CPT as a starting material have been provided from searching studies by the present inventors and others.

15 CTP-11, which is a hydrochloride trihydrate of 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin (hereinafter, referred to as SN-38B-11) derivatized from CPT, is a compound having high anti-tumor activity with low toxicity, and CPT-11 is widely sold as an anti-tumor agent (general name: irinotecan hydrochloride) at present.

20 **[0003]** However, since the amount of CPT that can be obtained from a natural material such as *Camptotheca acuminata*, which is a raw material, is extremely small, it is anticipated that it will become difficult to supply a sufficient amount of CPT as the demand of CPT-11, which is its effective derivative, increases, although means to procure the raw material including planting has been taken. Furthermore, since CPT-11 is prepared from a naturally-derived extract after isolation and purification, a difference in raw materials such as *Camptotheca acuminata* and *Nothapodytes foetida* may cause the inclusion of different impurities. Thus, when *Nothapodytes foetida* is used as the raw material, the extract contains 18,19-dehydrocamptothecin represented by a formula (1):



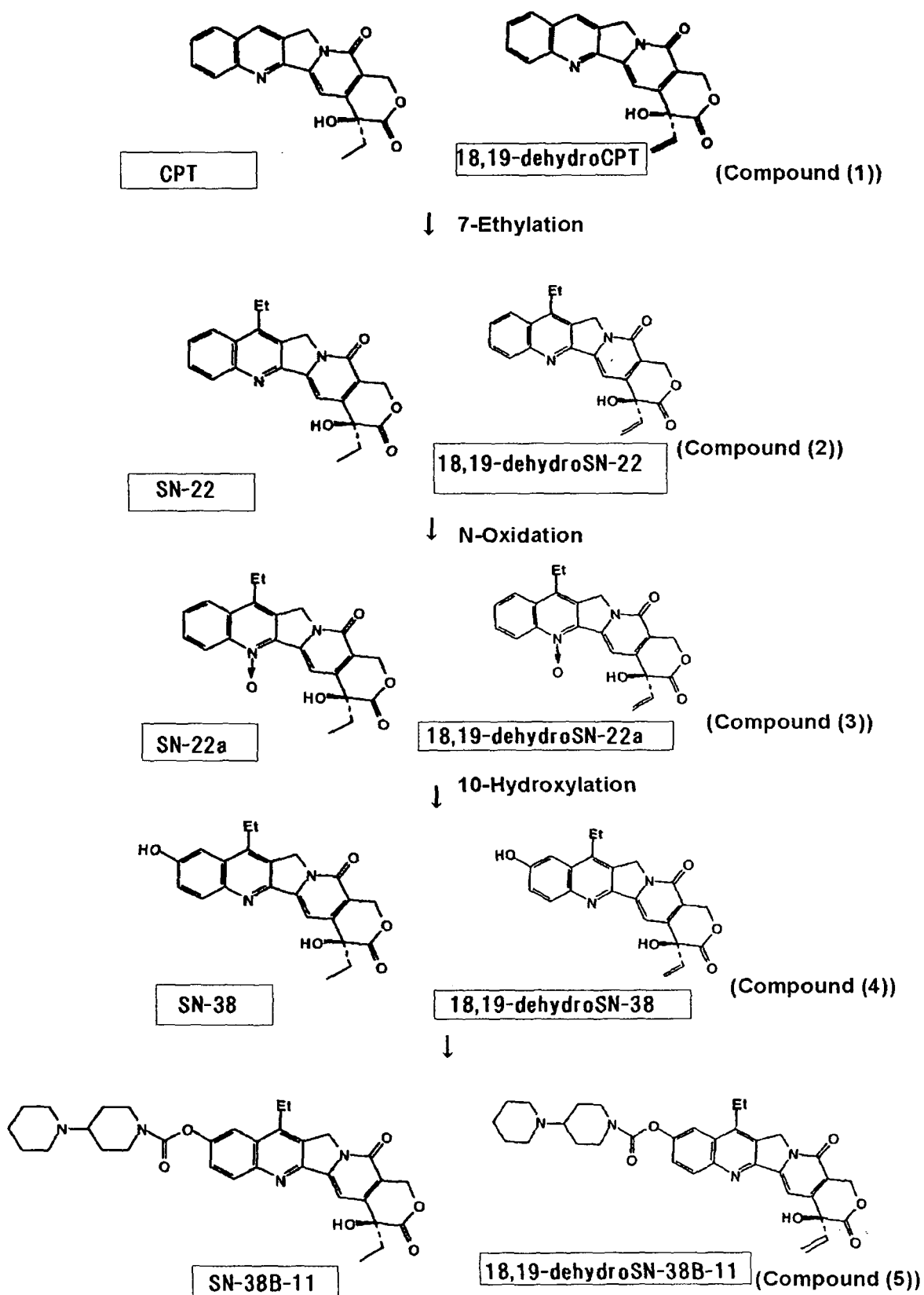
40 at a rate of several percent relative to CPT (refer to Patent document 1, Non-patent document 1). Regarding vinyl-form compounds having a vinyl group such as 18, 19-dehydrocamptothecin, the vinyl group remains in the subsequent production processes of CPT-11 as shown below, and the vinyl form cannot be completely removed by silica-gel column chromatography and others in any of the subsequent processes; therefore, it was difficult to obtain CPT-11 with high purity, when *Nothapodytes foetida* was used as the raw material.

[0004]

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Meanwhile, the problem of impurities will be solved when total synthesis is used; however, the preparation process by total synthesis has many problems in terms of equipment, yield and cost, so that the practical application has not yet been achieved.

[0005]

[Patent document 1] JP, A, 64-61482

[Non-patent document1] R. Aiyama, et al., Phytochemistry, Vol. 27, No. 11, pp. 3663-3664, 1988.

[Disclosure of the invention]

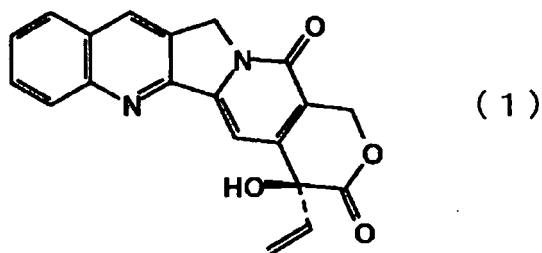
[Problem to be solved by the invention]

[0006] Therefore, an object of the present invention is to provide a process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptot hecin that does not comprise a vinyl form, from a camptothecin composition comprising 18,19-dehydrocamptothecin.

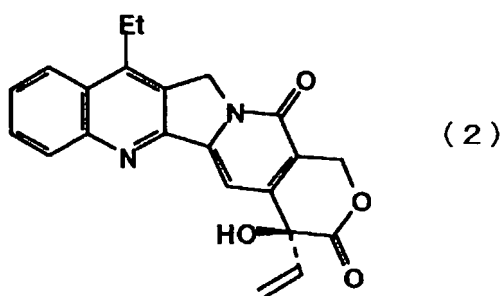
[Means of solving the problem]

[0007] During the present inventors' keen examination to solve the above-mentioned problem, they have found that, by the reduction under a certain condition of any one of the intermediates obtained by a process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptot hecin from CPT, while a double bond and a carbonyl group within the heterocyclic ring of the CPT or 18,19-dehydrocamptothecin are not reduced but only a vinyl group is reduced, so that finally 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptot hecin that does not comprise a vinyl form can be prepared; the present invention has thus been accomplished.

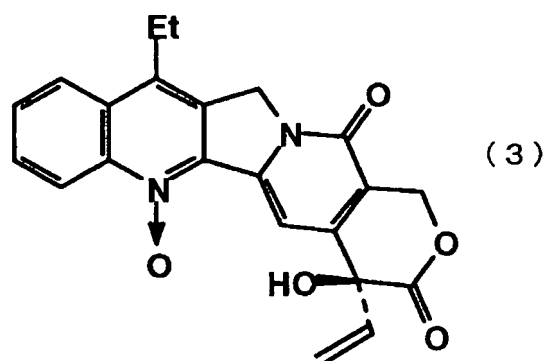
[0008] Namely, the present invention relates to a process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptot hecin from a composition comprising a compound represented by formula (1):



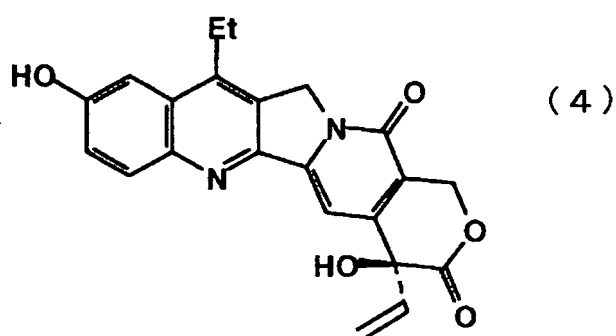
characterized in that in the process of producing a compound (2) :



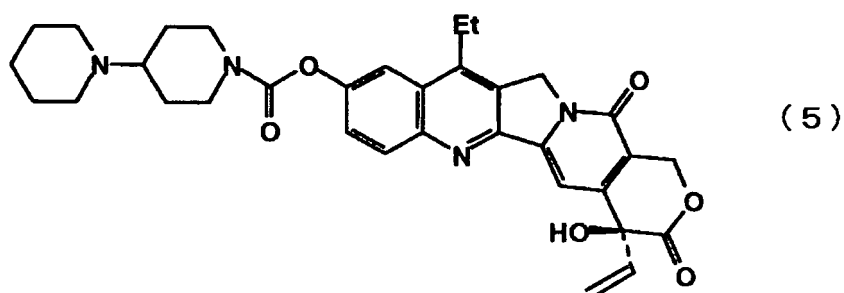
from the compound (1), then producing a compound (3):



from the compound (2), then producing a compound (4):



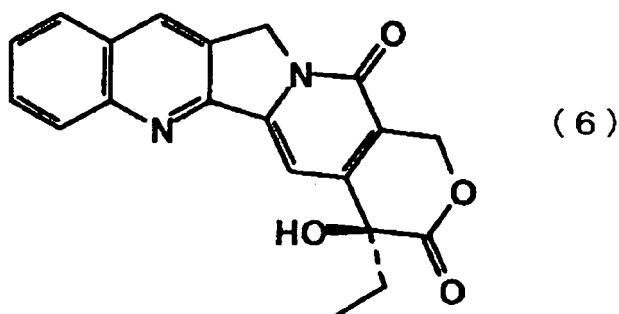
from the compound (3), and then producing a compound (5) :



from the compound (4), at least one compound selected from the compounds (1)-(5) is catalytically reduced.

[0009] In addition, the present invention relates to said process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino] carbonyloxycamptot hecin, characterized in that the compound (5) is catalytically reduced.

Furthermore, the present invention relates to said process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino] carbonyloxycamptot hecin, wherein the composition comprising the compound (1) is a mixture with a compound (6):



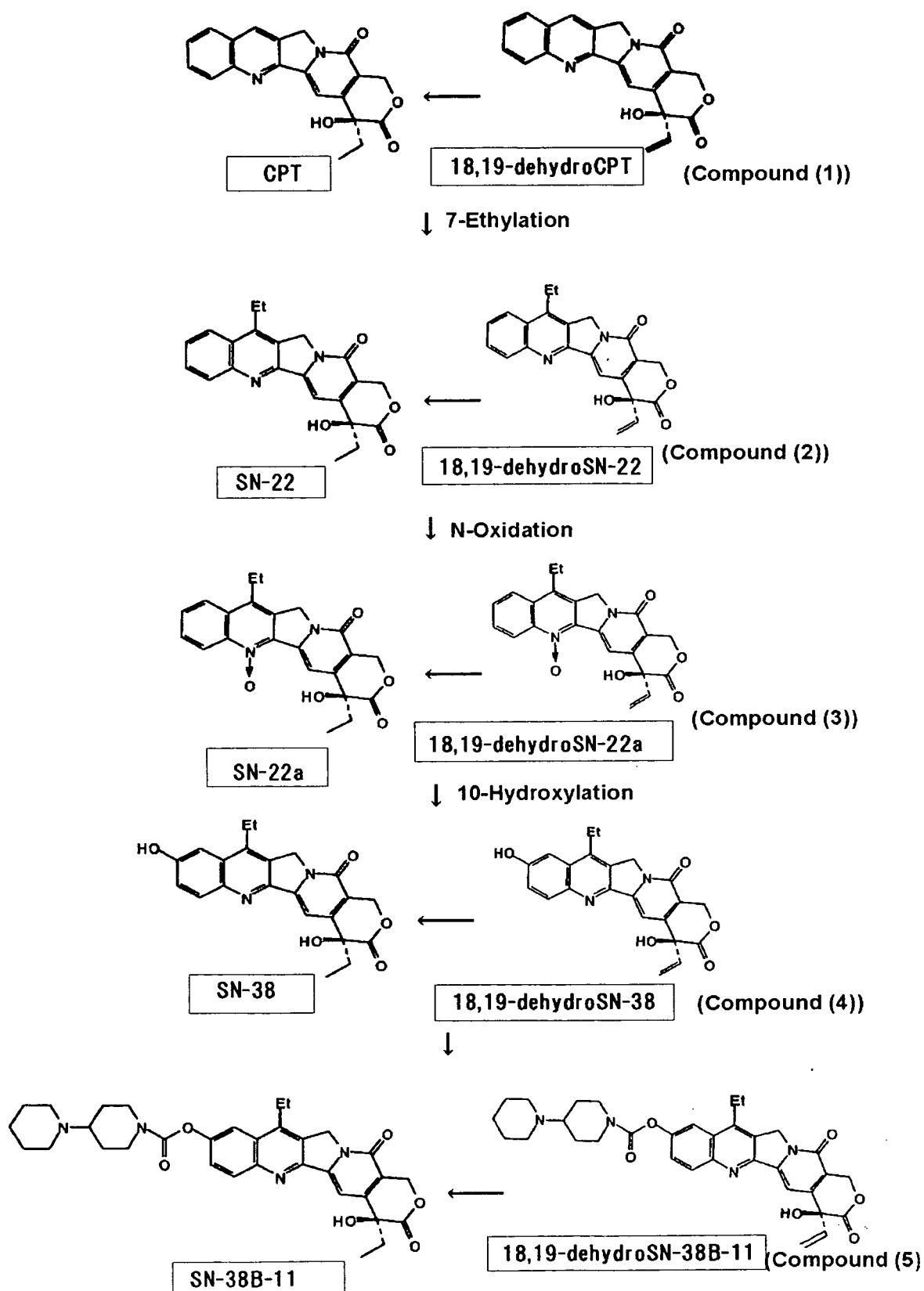
15 In addition, the present invention relates to said process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin, wherein the composition comprising the compound (1) is an extract of *Nothapodytes foetida*. Furthermore, the present invention relates to said process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin, wherein the catalytic reduction is performed under the presence of a catalyst using hydrogen or a formic acid or its salt as a hydrogen source.

20 **[Effects of the invention]**

[0010] According to the inventive process, it becomes possible to use a camptothecin composition comprising 18,19-dehydrocamptothecin such as a *Nothapodytes foetida* extract, which is difficult to be used to date as a raw material of CPT-11, in the preparation of 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin; the process exhibits extremely superior effects in terms of procurement of raw materials and improvement in product purities.

[Best mode of the invention]

30 **[0011]** A process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin according to the present invention is explained herein below; however, the present invention is not limited thereto. 7-Ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin is prepared from a camptothecin composition comprising 18,19-dehydrocamptothecin, by the following processes.



[0012] With respect to CPT that is a starting material as well as reaction conditions and others in each process, refer to JP A 62-42914, JP A 62-47193, JP A 3-68007 and WO 01/070747 which are incorporated herein by reference.

In the process of the present invention, by means of catalytically reducing any one of the above compounds (1)-(5), 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin that does not comprise a vinyl form, and its hydrochloride trihydrate, i.e., CPT-11, can finally be prepared.

Compared to the compounds (1)-(4), the compound (5) has a higher solubility to a reaction medium so that the amount of the reaction medium can be reduced; therefore, catalytic reduction can be performed at a high concentration, thereby increasing reaction efficiency when the same amount of a catalyst is used, and the catalytic reduction can be completed within a shorter period. Thus, the reduction of the compound (5) is particularly preferred.

[0013] Catalytic reduction can be performed under the presence of a catalyst, using hydrogen or a formic acid or its salt as a hydrogen source. Examples of the catalyst used include platinum-group catalysts such as palladium, platinum, rhodium, ruthenium and the like, or nickel-group catalysts such as nickel and the like, or salts thereof; palladium, rhodium, ruthenium and nickel are preferred, and palladium is particularly preferred. In addition, examples of the formate used as a hydrogen source include ammonium formate, triethylammonium formate and the like; ammonium formate is preferred.

The use of ammonium formate is most preferred from the viewpoint of safety and handling.

The process of the present invention can be applied to any camptothecin composition comprising 18, 19-dehydrocamptothecin; it is suitable for a 18,19-dehydrocamptothecin-containing composition extracted from *Nothapodytes foetida*.

[Examples]

[0014] The present invention is illustrated further in detail by reference to Examples.

Example 1

[0015] Catalytic reduction of 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin (SN-38B-11) that comprises 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxy-18,19-dehydrocamptothecin (18,19-dehydroSN-38B-11, compound (5))

[0016] A camptothecin comprising approximately 3% of 18,19-dehydrocamptothecin (compound (1)), which has been isolated and purified from *Nothapodytes foetida*, is prepared in accordance with the preparation process of SN-38B-11, giving a SN-38B-11 that comprises 18,19-dehydroSN-38B-11 (compound (5)).

The content of the vinyl form (compound (5)) in the SN-38B-11 obtained by isolation and purification is shown in Table 1 below.

[0017]

[Table 1]

SN-38B-11			
Vinyl form (%)	Sample 1	Sample 2	Sample 3
	1.63	1.94	1.95

[Test method]

[0018] The SN-38B-11 (100 mg) comprising the vinyl form (compound (5)) obtained by isolation and purification is dissolved in 20 mL of a dioxane-ethanol mixture solution (1:1) in a hydrogenation reaction vessel (100 mL), and approximately 10 mg of 10% Pd-C is added to the resultant mixture. Approximately 1.2 mL of the mixture is measured, filtered through a membrane filter (0.45 μ m), and 1 mL of the filtrate is precisely measured, which is then made precisely to a volume of 10 mL by adding a dissolved solution [MeOH-H₂O-0.1 N HCl (5:4:1)]; thus, an initial sample solution is obtained. The reaction vessel is deaerated under reduced pressure and shaken under hydrogen atmosphere. At 30, 60, 120 and 240 min thereafter, approximately 1.2 mL of the sample is measured, filtered through a membrane filter (0.45 μ m), and 1 mL of the filtrate is precisely measured, which is then made precisely to a volume of 10 mL by adding the dissolved solution; thus, a sample solution at each time point is obtained. Regarding 20 μ L of each sample solution, the content of the vinyl form (compound (5)) in the reaction mixture is measured under the HPLC operating conditions described below.

[0019]

[HPLC operating conditions]

Column: Inertsil ODS2, 5 μ m, 4.6 mm x 25 cm

Eluent: 20 mM PBS (pH 3.5)-MeOH-MeCN (3.5:1:1)

Detect: 254 nm

[0020]

[Table 2]

Time(min)	SN-38B-11		
	Sample 1	Sample 2	Sample 3
0	1.63	1.94	1.95
30	0.62	0.91	0.95
60	0.22	0.47	0.53
120	0.08	0.12	0.15
240	ND	ND	ND
% peak area			

[0021] After the above-described reaction, no vinyl form (compound (5)) was detected in any sample at 240 min after.

Example 2

[0022] Catalytic reduction of 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin (SN-38B-11) that comprises 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxy-18,19-dehydrocamptothecin (18,19-dehydroSN-38B-11, compound (5))

[0023] Catalytic reduction was performed using ammonium formate as the hydrogen source instead of hydrogen gas.

[Test method]

[0024] Crude SN-38B-11 was added and dissolved into methanol (60 v/w) and dioxane (15 v/w), and Pd-C (10%) (dry matter equivalent: 0.05, 0.05, 0.10 w/w) suspended in filtered water (approximately 0.2 w/w) was added to the resultant solution, which was then reacted by adding an ammonium formate (0.50, 1.00, 1.00 w/w); the content of the vinyl form (compound (5)) in the reaction mixture at 1, 2, 3 and 4 h after the reaction was measured by HPLC. Table 3 shows the results.

[0025]

[HPLC operating conditions]

Column: Chemcosorb 5-ODS-H, 4.6 mm ID x 150 mm

Eluent: 0.1% (v/v) phosphoric acid/CH₃CN(4/1)

Detect: 254 nm

Temperature: 40°C

Flow rate: 1 mL/min

[0026]

[Table 3]

Experiment No.	92-011	92-012	92-017
Pd-C (10%) dry matter equivalent (w/w)	0.05	0.05	0.10
Ammonium formate (w/w)	0.50	1.00	1.00
Vinyl form (compound (5)) before reaction	1.05%	1.05%	0.74%
Reaction time (hr)			
1	0.64%*	0.22%	ND
2	0.44%	0.05%	ND
3	0.38%	0.01%	ND
4	0.37%	-	-
% peak area of vinyl form			

[0027] By using 0.10 w/w of Pd-C (10%) (relative to the crude SN-38B-11) and 1.00 w/w of ammonium formate, the

reaction was completed in 60-180 min.

Example 3

5 Catalytic reduction of camptothecin (CPT) that comprises 18,19-dehydrocamptothecin (18,19-dehydroCPT, compound (1))

10 **[0028]** SN-38B-11 is prepared from a camptothecin comprising 18,19-dehydrocamptothecin (compound (1)) isolated from *Nothapodytes foetida*, in accordance with the preparation process of SN-38B-11, so that SN-22, SN-22a, and SN-38 that respectively comprise an intermediate 18,19-dehydroSN-22 (compound (2)), 18,19-dehydroSN-22a (compound (3)), and 18,19-dehydroSN-38 (compound (4)) are obtained. The contents of the vinyl form (compound (1), compound (2), compound (3), and compound (4)) in CPT, SN-22, SN-22a and SN-38 used in the test are shown in Table 4.

15 [Test method]

[0029] The CPT (100 mg) comprising the vinyl form (compound (1)) is dissolved in 200 mL of a dioxane-methanol mixture solution (1:1) in a recovery flask, and approximately 20 mg of 10% Pd-C is added to the resultant mixture. Approximately 1 mL of the mixture is measured and filtered through a membrane filter (0.45 μm), giving an initial sample solution. The reaction vessel is deaerated under reduced pressure and vigorously stirred under hydrogen atmosphere at room temperature. At 1, 3, and 5 hr thereafter, approximately 1 mL of the sample is measured and filtered through a membrane filter (0.45 μm), giving a sample solution at each time point. Regarding 20 μL of each sample solution, the content of the vinyl form (compound (1)) in the reaction mixture is measured under the HPLC operating conditions described below.

25 Table 4 shows the experimental results. No vinyl form (compound (1)) was detected at 5 hr after.

[0030]

[HPLC operating conditions]

Column: Chemcosorb 5-ODS-H, 4.6 mm ID x 150 mm

30 Temperature: 40°C

Eluent: Methanol/0.1% (v/v) phosphoric acid (53/47) mixture solution

Detect: 254 nm

Flow rate: 0.8 mL/min

35 Example 4

Catalytic reduction of 7-ethylcamptothecin (SN-22) that comprises 7-ethyl-18,19-dehydrocamptothecin (18,19-dehydroSN-22, compound (2))

40 [Test method]

[0031] The SN-22 (100 mg) comprising the vinyl form (compound (2)) is dissolved in 100 mL of a dioxane-ethanol mixture solution (1: 1) in a recovery flask, and approximately 10 mg of 10% Pd-C is added to the resultant mixture. Approximately 1 mL of the mixture is measured and filtered through a membrane filter (0.45 μm), giving an initial sample solution. The reaction vessel is deaerated under reduced pressure and vigorously stirred under hydrogen atmosphere at room temperature. At 1, 3, 5 and 7 hr thereafter, approximately 1 mL of the sample is measured and filtered through a membrane filter (0.45 μm), giving a sample solution at each time point. Regarding 10 μL of each sample solution, the content of the vinyl form (compound (2)) in the reaction mixture is measured under the HPLC operating conditions of Example 3.

50 Table 4 shows the experimental results. No vinyl form (compound (2)) was detected at 7 hr after.

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Example 5

Catalytic reduction of 7-ethylcamptothecinN-oxide (SN-22a) that comprises 7-ethyl-18,19-dehydrocamptothecin N-oxide (18,19-dehydroSN-22s, compound (3))

[Test method]

[0032] With respect to the SN-22a (100 mg) comprising the vinyl form (compound (3)), a sample solution is prepared and collected by the catalytic reduction process similar to that in Example 4, and the content of the vinyl form (compound (3)) in the reaction mixture is measured under the HPLC operating conditions shown below.

Table 4 shows the experimental results. No vinyl form (compound (3)) was detected at 7 hr after.

[0033]

[HPLC operating conditions]

Column: Chemcosorb 5-ODS-H, 4.6 mm ID x 150 mm

Temperature: 35°C

Eluent: Methanol/0.1% (v/v) phosphoric acid (53/47) mixture solution

Detect: 254 nm

Flow rate: 0.8 mL/min

Example 6

Catalytic reduction of 7-ethyl-10-hydroxycamptothecin (SN-38) that comprises 7-ethyl-10-hydroxy-18,19-dehydrocamptothecin (18,19-dehydroSN-38, compound (4))

[Test method]

[0034] The SN-38 (100 mg) comprising the vinyl form (compound (4)) is dissolved in 40 mL of a dioxane-methanol mixture solution (1: 1) in a recovery flask, and approximately 20 mg of 10% Pd-C and 0.15 mL of water are added to the resultant mixture. Approximately 0.5 mL of the mixture is measured and filtered through a membrane filter (0.45 μ m), giving an initial sample solution. Ammonium formate (100 mg) is added to this mixture and vigorously stirred at room temperature. At 1 and 3 hr thereafter, approximately 0.5 mL of the sample is measured and filtered through a membrane filter (0.45 μ m), giving a sample solution at each time point. Regarding 4 μ L of each sample solution, the content of the vinyl form (compound (4)) in the reaction mixture is measured under the HPLC operating conditions of Example 3.

Table 4 shows the experimental results. No vinyl form (compound (4)) was detected at 3 hr after.

[0035]

[Table 4]

Reaction Time(hr)	Content of vinyl form (%)			
	Compound(1)	Compound(2)	Compound(3)	Compound(4)
0	1.41	1.25	1.13	1.06
1	0.73	0.52	0.59	0.11
3	0.18	0.12	0.18	ND
5	ND	0.02	0.16	-
7	-	ND	ND	-

Reference test

Removal of 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptothecin (SN-38B-11) that comprises 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxy-18,19-dehydrocamptothecin (18,19-dehydroSN-38B-11, compound (5)) by means of silica gel chromatography

[0036] Regarding 200 mg of the sample 1 in Table 1, Table 5 shows the fractionation by column chromatography using silica gel with an amount approximately 150 times and its analytical results.

[Test method]

[0037] The sample 1 is charged on a silica gel column (Merck Silica Gel 60, 230-400 mesh ATMS, 2 x 10 cm, approximately 30 g) and is flown down with a CHCl_3 -MeOH (20: 1) mixture solution (10 mL/min). The flowing-down solution is fractionated by 30 mL. Each fraction is concentrated to dryness under reduced pressure, and the residue is dissolved into a dissolving solution to achieve the concentration of 1 mg/mL, giving a sample solution. 10 μL of the sample solution is tested under the HPLC operating conditions shown below.

Dissolving solution: MeOH- H_2O -0.1 N HCl (5:4:1)

[0038]

[HPLC operating conditions]

Column: Inertsil ODS2, 5 μm , 4.6 mm x 25 cm

Eluent: 20 mM PBS (pH 3.5)-MeOH-MeCN (3.5:1:1)

Detect: 254 nm

[0039]

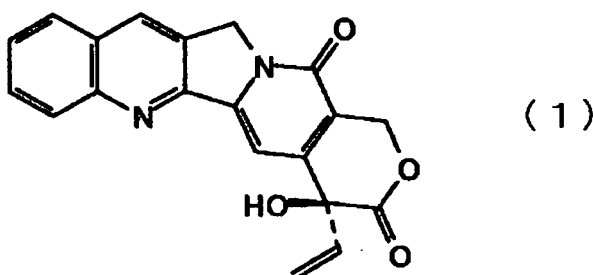
[Table 5]

Fr.No.	(g)	Vinyl form (compound (5)) (%)	SN-38B-11 (%)
1	0.05	0.36	97.33
2	0.05	0.76	98.62
3	0.03	1.36	98.16
4	0.02	2.17	97.62
5	0.02	2.47	97.25
6	0.01	2.52	97.23
7	0.01	2.79	96.81
8	0.01	2.76	96.62
			% peak area

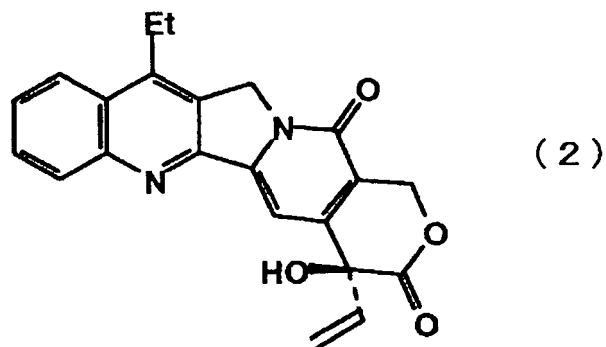
[0040] The contents of the vinyl form increased at the latter portions of the SN-38B-11 fractions. The removal of the vinyl form was therefore difficult under these operating conditions.

Claims

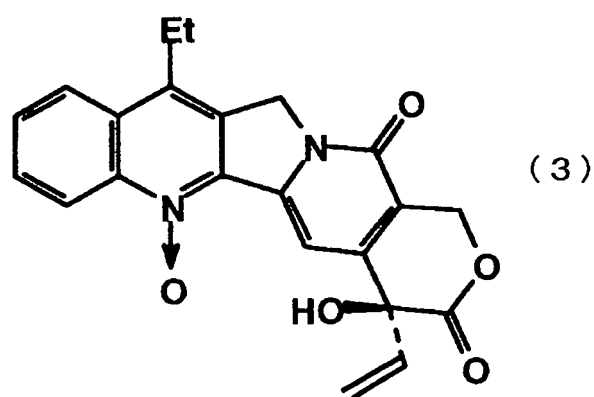
1. A process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptot hecin from a composition comprising a compound represented by formula (1):



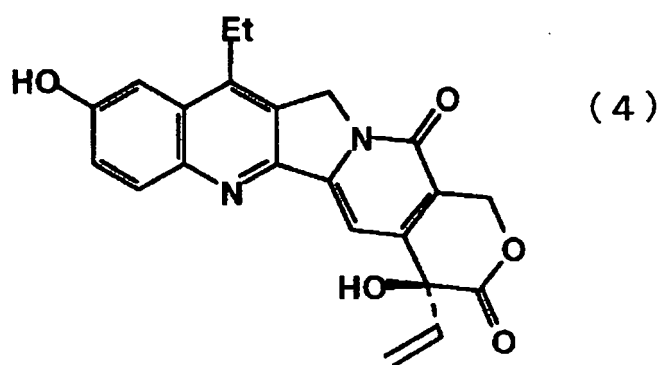
characterized in that in the process of producing a compound (2) :



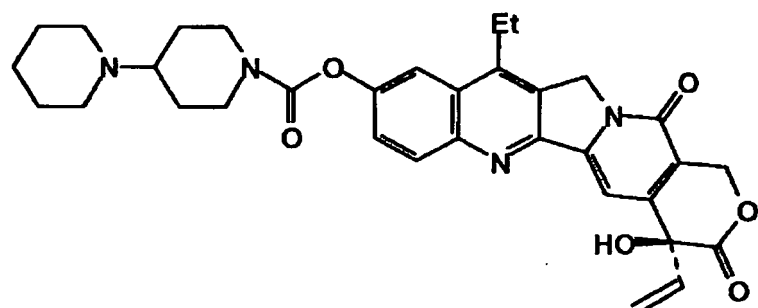
15 from the compound (1), then producing a compound (3):



35 from the compound (2), then producing a compound (4):

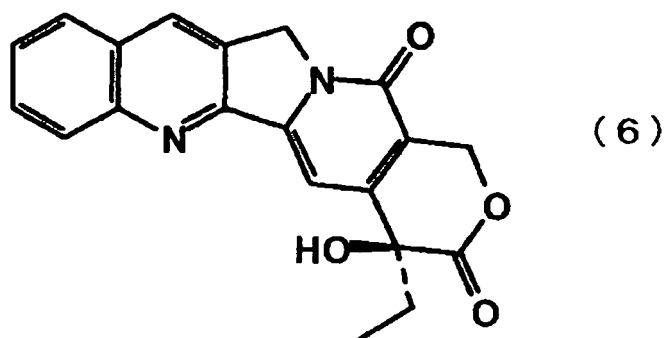


50 from the compound (3), and then producing a compound (5):



from the compound (4), at least one compound selected from the compounds (1)-(5) is catalytically reduced.

2. The process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptot hecin according to Claim 1, **characterized in that** the compound (5) is catalytically reduced.
3. The process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptot hecin according to Claim 1 or 2, wherein the composition comprising the compound (1) is a mixture with a compound (6):



4. The process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptot hecin according to any one of Claims 1 to 3, wherein the composition comprising the compound (1) is an extract of *Nothapodytes foetida*.
5. The process for preparing 7-ethyl-10-[4-(1-piperidino)-1-piperidino]carbonyloxycamptot hecin according to any one of Claims 1 to 4, wherein the catalytic reduction is performed under the presence of a catalyst using hydrogen or a formic acid or its salt as a hydrogen source.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP2007/059155

A. CLASSIFICATION OF SUBJECT MATTER

C07D491/22 (2006.01) i, C07B53/00 (2006.01) n

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

C07D491/22, C07B53/00

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Jitsuyo Shinan Koho 1922-1996 Jitsuyo Shinan Toroku Koho 1996-2007
 Kokai Jitsuyo Shinan Koho 1971-2007 Toroku Jitsuyo Shinan Koho 1994-2007

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

CAPLUS (STN), CAOLD (STN), REGISTRY (STN), MEDLINE (STN), BIOSIS (STN),
 EMBASE (STN), WPIDS (STN)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y A	JP 2004-521909 A (Boehringer Ingelheim Pharma GmbH & Co. KG.), 22 July, 2004 (22.07.04), Full text; particularly, Claims; page 4; Par. Nos. [0004] to [0005]; pages 5 to 6; Par. Nos. [0012] to [0014]; page 7; Par. Nos. [0017] to [0020] & US 2002/111489 A1 & EP 1362051 B1 & WO 2002/064597 A2 & CA 2435372 A & NO 20033614 A & CZ 20032211 A & HU 303030 A & SK 10192003 A & BR 207261 A & PL 362128 A & CN 1491228 A & BG 108064 A & HR 20030654 A & HK 1064092 A & NZ 528039 A	1, 3-5 2

☒ Further documents are listed in the continuation of Box C.☐ See patent family annex.

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Date of the actual completion of the international search
 24 May, 2007 (24.05.07)

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 05 June, 2007 (05.06.07)

Name and mailing address of the ISA/
 Japanese Patent Office

Authorized officer

Facsimile No.

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INTERNATIONAL SEARCH REPORT

International application No.

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C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

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Y A	SAWADA, S. et al., Synthesis and Antitumor Activity of 20(S)-Camptothecin Derivatives: Carbamate-Linked, Water-Soluble Derivatives of 7-Ethyl-10-hydroxycamptothecin, Chemical & Pharmaceutical Bulletin, 1991.06.25, Vol.39/No.6, p.1446-1454	1,3-5 2
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REFERENCES CITED IN THE DESCRIPTION

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